

# Work Order ID 66238

February 8, 2011 8:43:45 AM



Page 1

Item ID:	D3535-15	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	2/08/11	Start Qty: 6.00		Cust Item ID:		
Required Date:	2/22/11	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>1/10/08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3535		<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-				
<u>304 . 040</u>	Deburr if necessary								(6)

B11-2-15

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-2-15

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

S 1/10/16

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66238**

February 8, 2011 8:43:45 AM

Page 3

Item ID: D3535-15

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 2/08/11 Start Qty: 6.00

Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/02/23

170

Identify as per dwg & Stock Location FP-18 0.00

Packaging

Memo

0.00

Packaging

6 BR 11-2-28

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/02/24

MF  
11-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 8, 2011 8:43:44 AM

Page 1

Work Order ID: 66238



Parent Item: D3535-15



Parent Item Name: Wearshoe

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

149.5538

1.0205

6.445263



304/316 .040 Sheet

B 11-2-15

Location

Loc Qty

Loc Code

MAT

149.5538

115953

21.6

116437

52.7538

116623

75.2

116623

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	66238
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-15
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	x	V	V HB02	
2.000	+/-0.010	2.000	x		V	
5.650	+/-0.010	5.650	V		T	
9.150	+/-0.010	9.156	x		T	
14.400	+/-0.010	14.400	x		T	
19.650	+/-0.010	19.650	x		T	
24.900	+/-0.010	24.900	x		T	
30.150	+/-0.010	30.150	x		T	
33.650	+/-0.010	33.650	x		T	
35.650	+/-0.010	35.650	x		T	
39.150	+/-0.010	39.150	x		T	
Ø0.188	+0.005/-0.001	.191	x		V	
24.00	+/-0.030	24.00	x		T	
16.00	+/-0.030	16.00	x		T	
8.00	+/-0.030	8.00	2		T	
5.00	+/-0.030	5.00	2		T	
0.300	+/-0.010	.304	6		V	
0.300	+/-0.010	.304	2		V	
0.038	+/-0.010	.037	2		V	

<b>Measured by:</b>	B
<b>Date:</b>	11-2-15

<b>Audited by:</b>	S
<b>Date:</b>	11/02/16

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

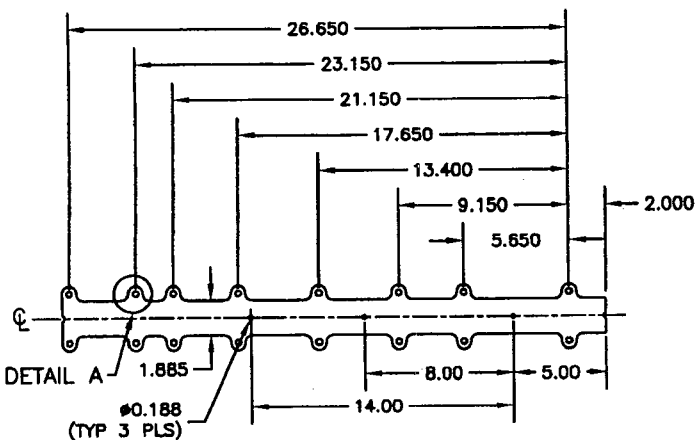
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

**DART**

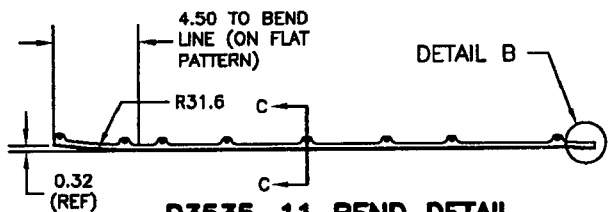
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07.04.24

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

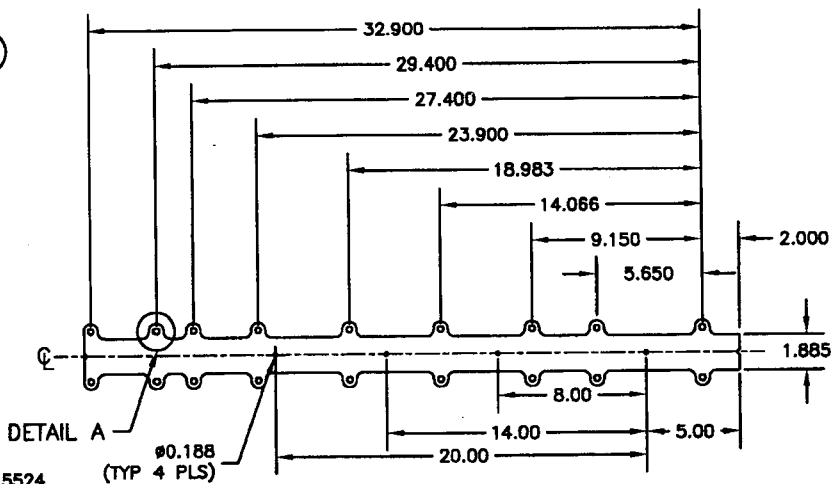


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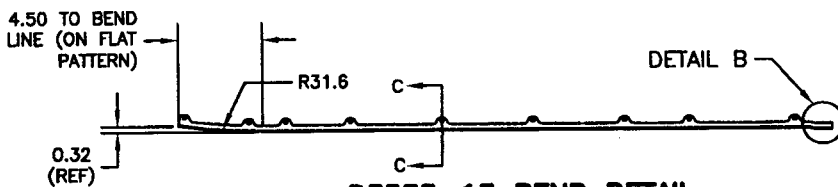


**D3535-11 BEND DETAIL**

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WORK ORDER  
NO. 660238  
02/11/05/108



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

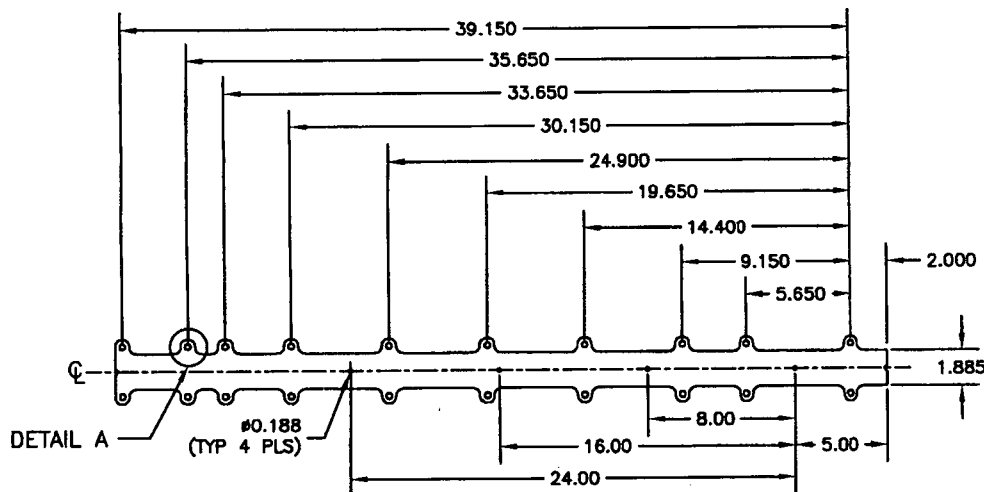
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

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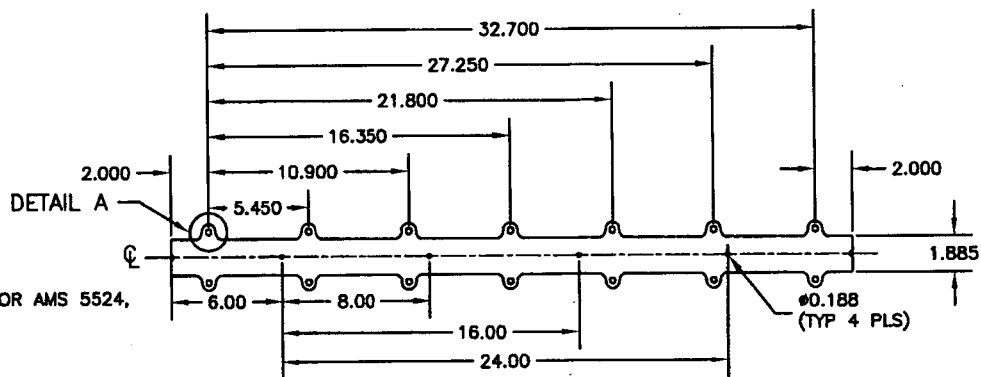
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		D3535	SHEET 2 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)**D3535-15F FLAT PATTERN**0.32  
(REF)**D3535-15 BEND DETAIL**

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**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN**

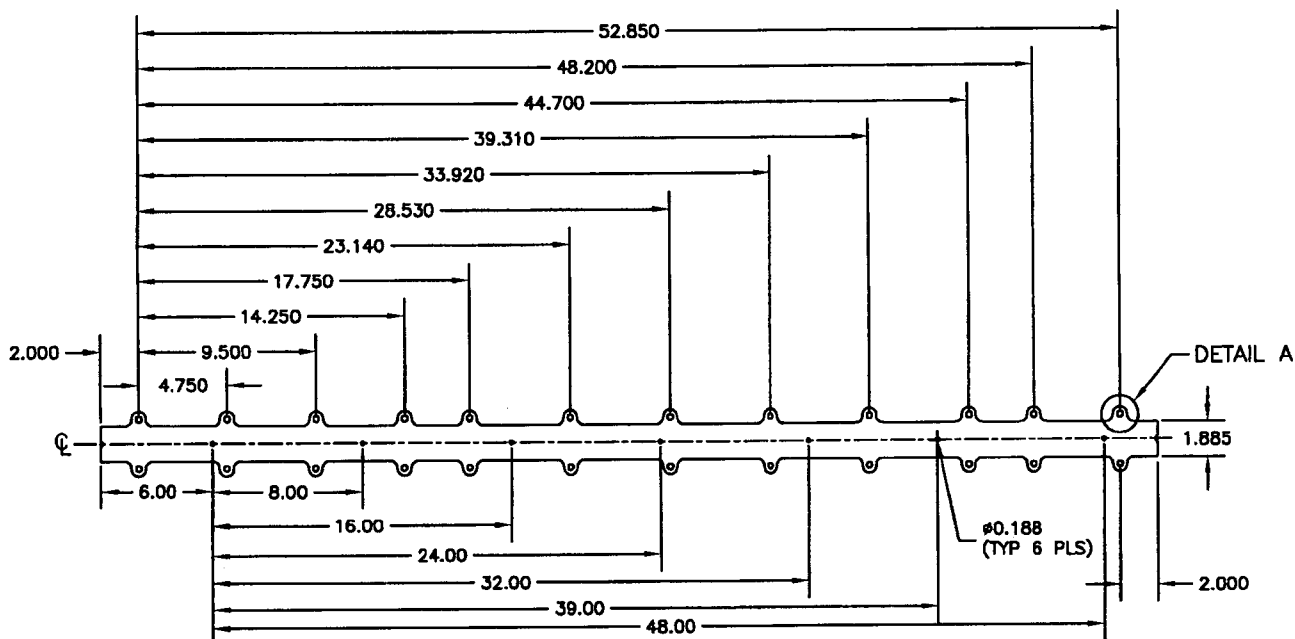
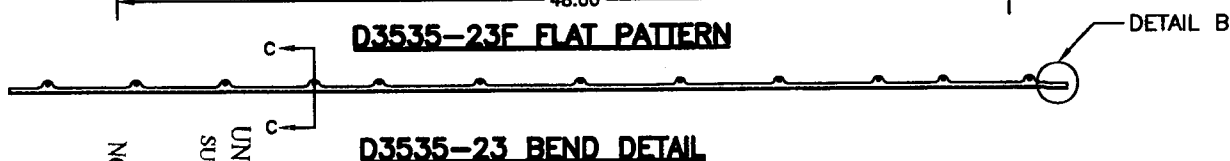
DETAIL B

**D3535-21 BEND DETAIL**

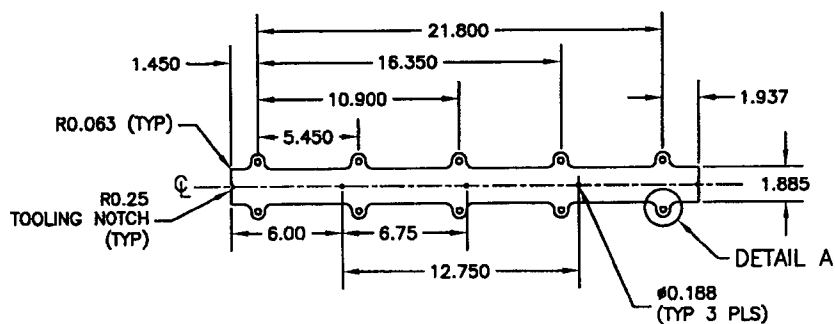
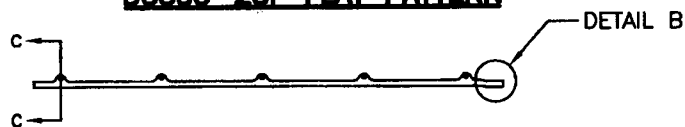
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**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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#	#	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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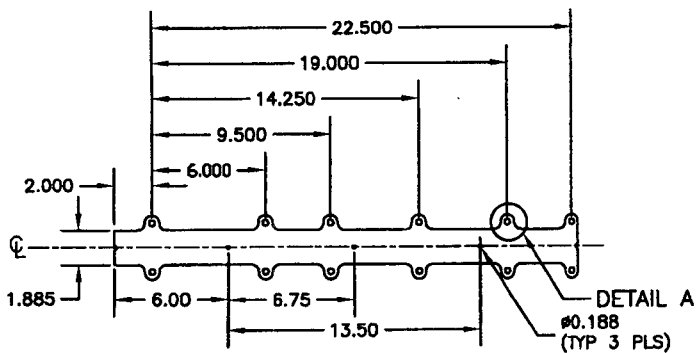
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		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	

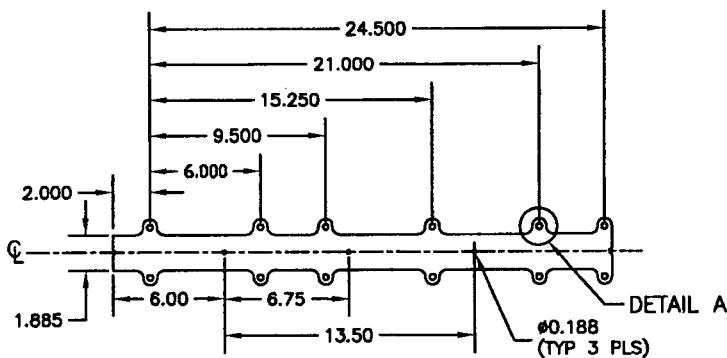


**D3535-31F FLAT PATTERN**



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**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES**

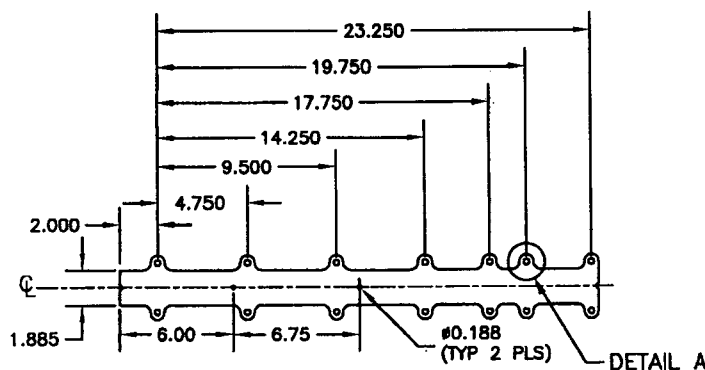
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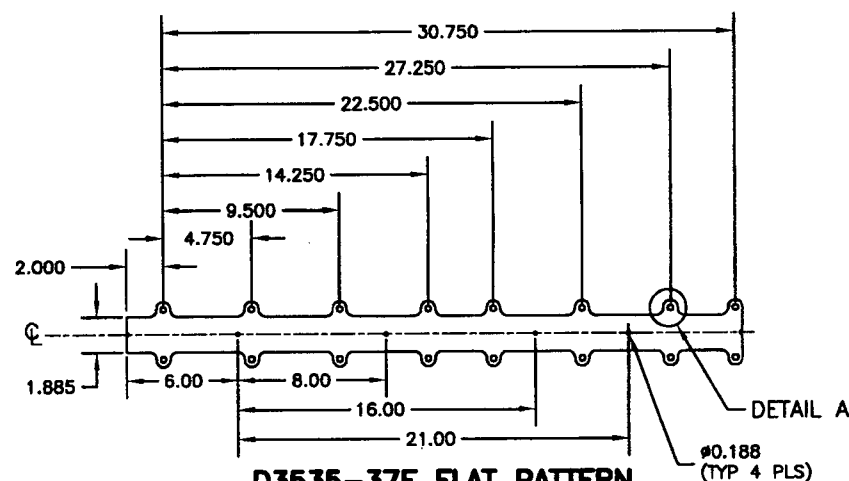
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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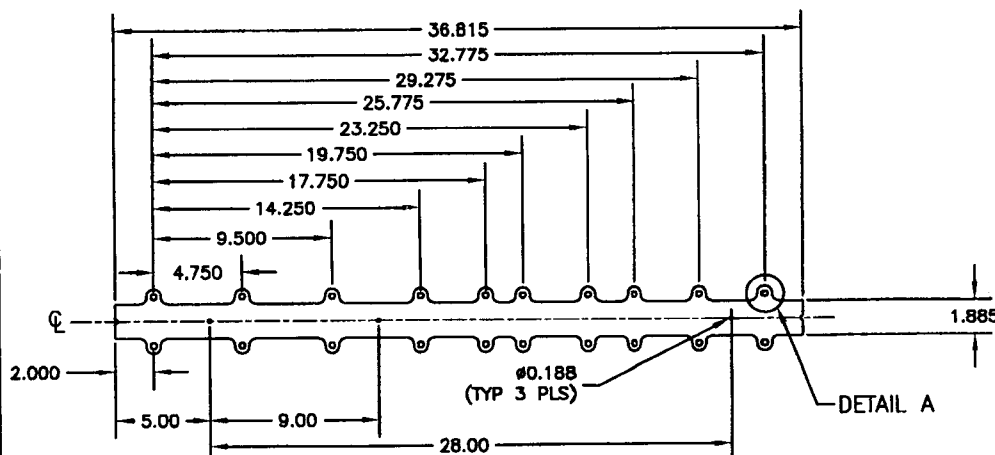
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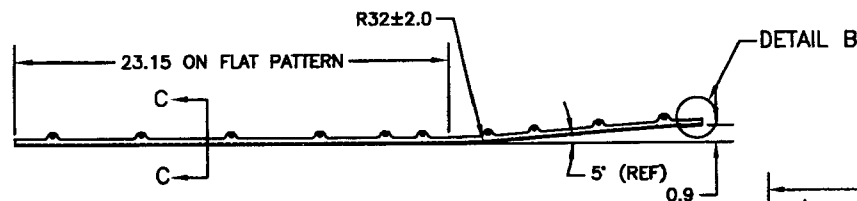
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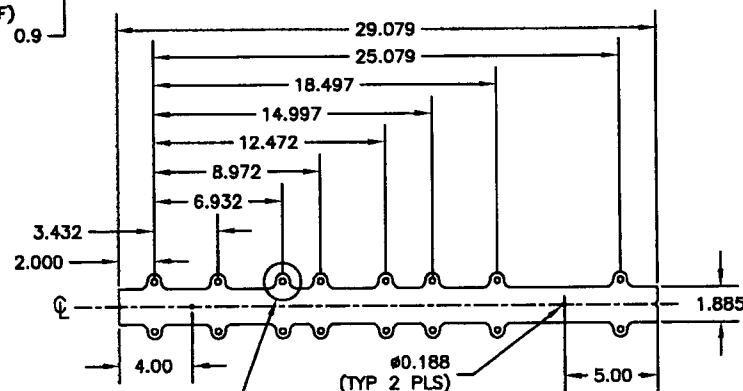


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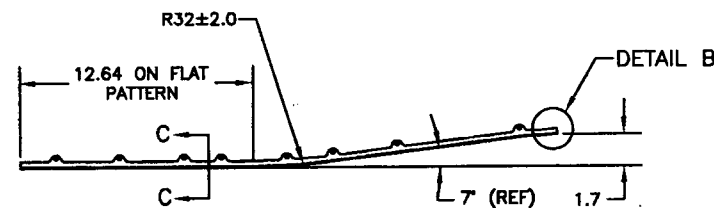
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**NOTES**

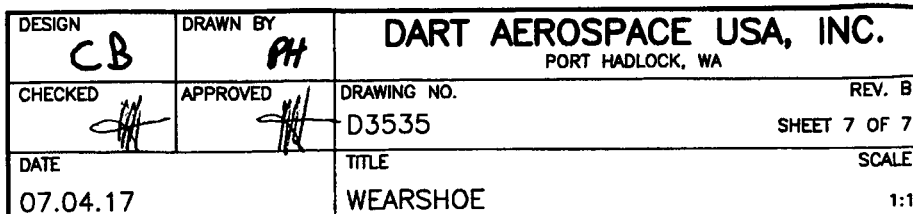
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**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**



07.04.24



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